

Work Order ID 85086

Friday, June 01, 2012 3:26:16 PM

85086

Page 1

Item ID: PB67-43001-27

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade Positioner

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-27

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- slide -289 , -291 and -293 on -19 tube then slide it in -285 tube2- drill holes
0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg 3-
assemble all parts as per dwg PB67-43001

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location **437**

0.00

120

Packaging

Memo

0.00

Packaging

1 ϕ *ll*
12.06.19 ϕ *R12/20* (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/6/2012
ML 12/06/20

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Picklist Print

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Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev C 10.09.28 per rev C
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
*PB67-43001-19 Inner Tube and Retainer Bushing		Manufactured	No	B 85114 = (1)		100	Each	0.0000	1	1		12.06.19	
✓PB67-43001-29 Blade Positioner Weldment		Manufactured	No			100	Each	1.0000	1	1		12.06.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST431A		1							
				62118		1							
PB67-43001-31 PB67-43001-31 Upper Restraint Weldment		Manufactured	No	B 41377		100	Each	4.0000	1	1		12.06.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST431A		4							
				53335		4							
PB67-43001-35 PB67-43001-35 Lower Pad Assembly		Manufactured	No			100	Each	5.0000	1	1		12.06.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST431A		5							
				45030		5							
PB67-43001-285 Upper Tube, Blade Positioner		Manufactured	No	B 85115 = (1)		100	Each	0.0000	1	1		12.06.19	
PB67-43001-289 Stationary Handle Adjustment Fitting		Manufactured	No			100	Each	4.0000	1	1		12.06.19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST439		4							
				62117		4							

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Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

✓ PB67-43001-291

Clamp Bushing

Manufactured No

100 Each 4.0000 1 1

12.06.19

Location

Loc Qty

Loc Code

ST439

4

~~44972~~

1

62121

3

1

✓ PB67-43001-293

Extension Tube Adjustment Fitting

Manufactured No

100 Each 6.0000 1 1

12.06.19

Location

Loc Qty

Loc Code

ST439

6

~~47365~~

6

1

✓ JAN6-22A

BOLT

Purchased No

100 Each 24.0000 1 1

12.06.19

Location

Loc Qty

Loc Code

ST342

24

~~110155~~

7

~~111060~~

17

1

✓ MS21042L6

Nut

Purchased No

100 Each 648.0000 1 1

12.06.19

Location

Loc Qty

Loc Code

ST300

648

117677

25

118384

3

118927

48

~~119075~~

372

120308

200

1

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Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-04

Purchased

No

100

Each

411.0000

3

3

SCREW

12.06.19

Location

Loc Qty

Loc Code

ST291

411

119638

3

120142

100

120308

34

120910

74

121476

200

3

MS27039-1-08

Purchased

No

100

Each

1,529.0000

1

1

Screw

12.06.19

Location

Loc Qty

Loc Code

ST291

1529

117423

81

119075

1

120308

404

121011

43

121243

500

121708

500

1

MS27039-1-09

Purchased

No

100

Each

273.0000

6

6

Screw

12.06.19

Location

Loc Qty

Loc Code

FP002

93

18057

93

ST291

180

111650

180

6

MS51859-8

Purchased

No

100

Each

46.0000

2

2

WASHER

12.06.19

Location

Loc Qty

Loc Code

ST296

46

112940

46

2

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Parent Item: PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0316P
WASHER

Purchased

No

100

Each

245.0000

7

7

12.06.19

Location

Loc Qty

Loc Code

ST275

245

112940

45

113237

100

113644

100

7

NAS1149F0363P
Washer

Purchased

No

100

Each

281.0000

3

3

12.06.19

Location

Loc Qty

Loc Code

ST275

281

113254

2

114382

79

121476

200

3

NAS1149F0632P
WASHER

Purchased

No

100

Each

465.0000

2

2

12.06.19

Location

Loc Qty

Loc Code

ST275

465

18057

465

2

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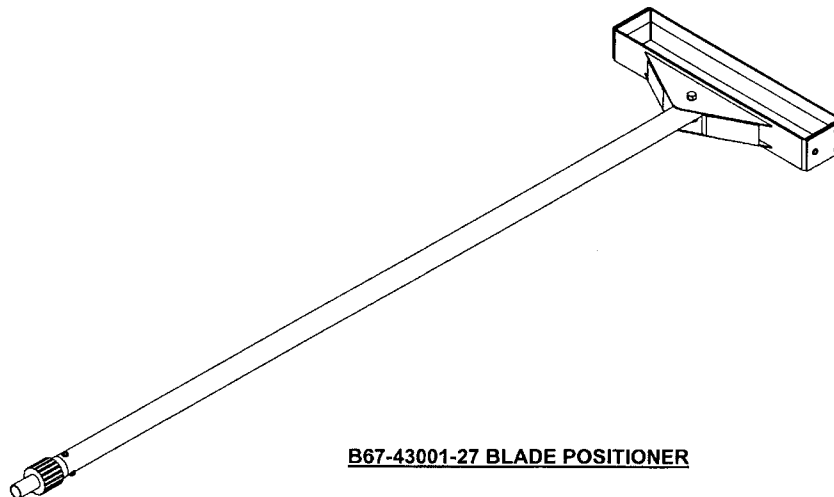
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B67-43001-27 BLADE POSITIONER

ITEM	QTY. -27	P/N	DESCRIPTION
	X	B67-43001-27	BLADE POSITIONER
1	1	B67-43001-19	INNER TUBE AND RETAINER BUSHING
2	1	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-31	UPPER RESTRAINT ASSEMBLY
4	1	B67-43001-35	LOWER PAD ASSEMBLY
5	1	B67-43001-285	UPPER TUBE, BLADE POSITIONER
6	1	B67-43001-289	STATIONARY HANDLE ADJUSTMENT FITTING
7	1	B67-43001-291	CLAMP BUSHING
8	1	B67-43001-293	EXTENSION TUBE ADJUSTMENT FITTING
9	1	AN6-22A	BOLT
10	1	MS21042L6	NUT
11	3	MS27039-1-04	SCREW
12	1	MS27039-1-08	SCREW
13	6	MS27039-1-09	SCREW
14	2	MS51859-8	WASHER
15	7	NAS1149F0316P	WASHER
16	3	NAS1149F0363P	WASHER
17	2	NAS1149F0632P	WASHER

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 7.07 lbs
- 8) DRILL THRU B67-43001-285/-289 PRIOR TO ASSEMBLY
- 9) DO NOT TORQUE NUT ON BOLT: TIGHTEN UNTIL SNUG
- 10) MATCH DRILL \varnothing 0.193 HOLE THRU B67-43001-29 WITH NUTPLATES LOCATED ON B67-43001-35

RELEASED
2010-09-21
JMM

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 4 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		VS	10.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED	VS	DRAWING NO.	REV. C	
MFG. APPR.	VS	B67-43001-27	SHEET 1 OF 3	
APPROVED	VS	TITLE	SCALE	
DE APPR.	VS	BLADE POSITIONER	NTS	
DATE	10.06.10		<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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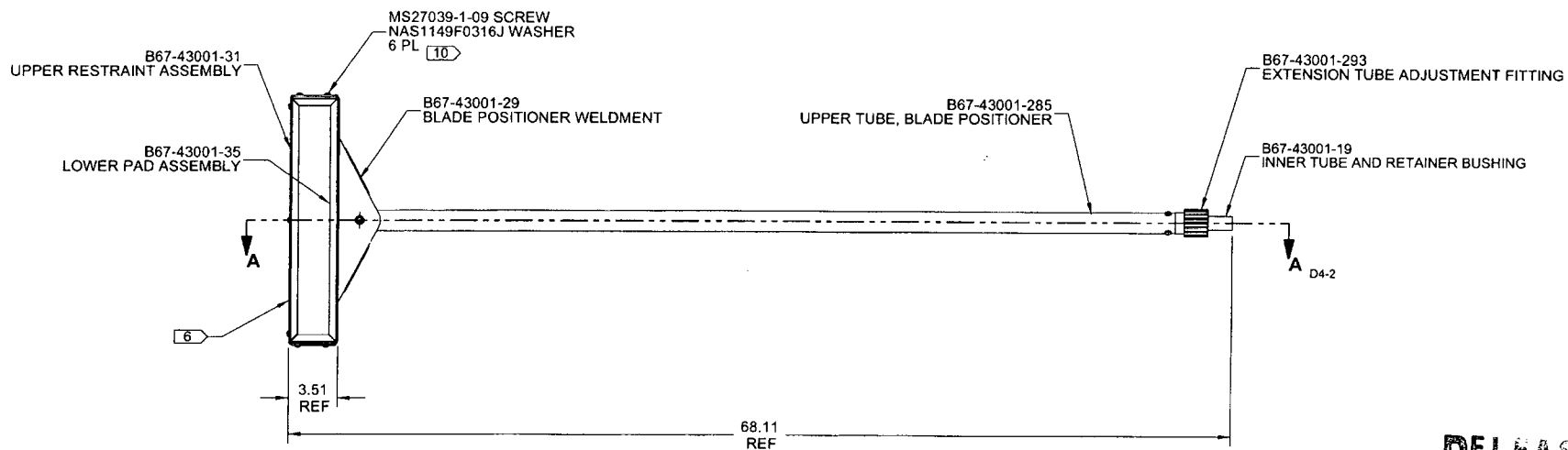
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SECTION A-A B2-2



B67-43001-27 BLADE POSITIONER

RELEASED
2010-09-21

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 2 OF 3
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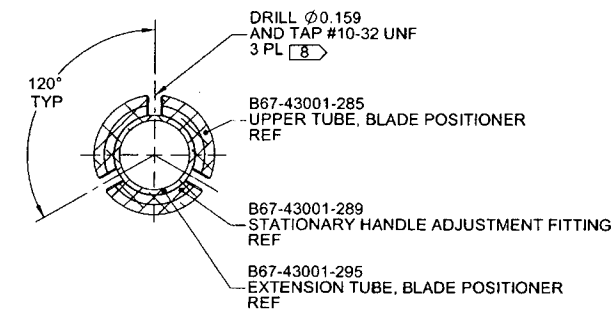
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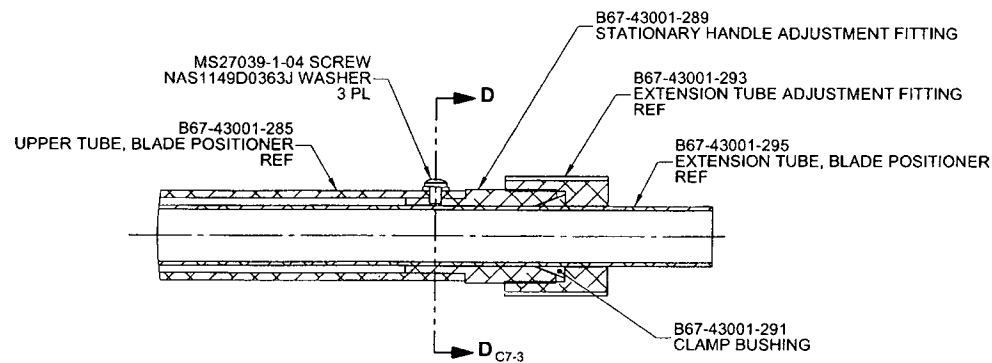
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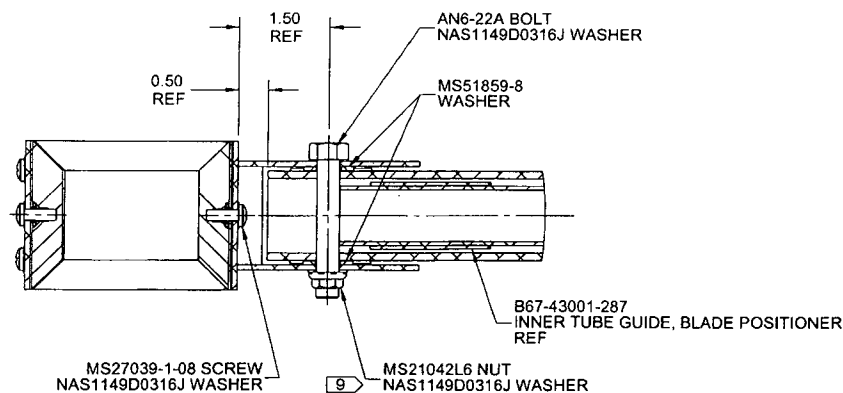
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SECTION D-D C3-3
(HARDWARE NOT SHOWN FOR CLARITY)



DETAIL C D3-2
SCALE 4X



DETAIL B D7-2
SCALE 4X

RELEASED
R 2010-09-21
JP

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 3 OF 3
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